



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

DAS
21
9-00

647.1812

Job Sheet 202746



Part No: 647.1812

Job Qty: 30 pcs

Part Name: Shim



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/1/19

Job Tracking No:

Due Date: 12/13/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV N/C SHEET 3 IPP REV:A 12.10.03 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Waterjet - Flow - 1	30 pcs		12/13/19	0.17	1.33	Waterjet - Flow		JLB 11/11/19
120	QC 2	30 pcs		12/13/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
TEL: (613) 632-5200
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Email: sales@dartaero.com
www.dartaero.com



Container No: S230494

Part: 647.1812

Job No: 202746

Serial No/Batch: S230494

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/11/19

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130 QC 8	30 pcs	12/13/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	DAS NOV 13 2019 40 9:00
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
140 Outsource - 4 - Anodize	30 pcs	12/13/19		ATG001-VC	10 2019-11-13
150 Packaging 2-1 - Receive - B4B	30 pcs	12/13/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	NOV 22 2019
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	

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					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
160	QC 6	30 pcs	12/13/19	0.00 0.00	QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	
					QC 6 - 40	
					QC 6 - 81	
170	Spray Paint - 2 - B4B	30 pcs	12/13/19	0.00 0.40	Spray Paint - 1 - B4B	
					Spray Paint - 2 - B4B	
					Spray Paint - 3 - B4B	
					Spray Paint - 4 - B4B	
180	QC 14	30 pcs	12/13/19	0.00 0.00	QC 14 - 15	
					QC 14 - 2	
					QC 14 - 34	
					QC 14 - 41	
					QC 14 - 51	
					QC 14 - 58	
					QC 14 - 59	
					QC 14 - 9	
					QC 14 - 68	
					QC 14 - 40	
					QC 14 - 19	
					QC 14 - 43	
					QC 14 - 24	
					QC 14 - 61	
					QC 14 - 81	
190	Packaging 3-1 - Stock - B4B	30 pcs	12/13/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	

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				Packaging 3 - 3 - B4B		
				Packaging 3 - 4 - B4B		
				Packaging 3 - 5 - B4B		
				Packaging 3 - 6 - B4B		
				Packaging 3 - 7 - B4B		
				Packaging 3 - 8 - B4B		
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 - B4B		
				Packaging 3 - 17 - B4B		
				Packaging 3 - 18 - B4B		
				Packaging 3 - 19 - B4B		
				Packaging 3 - 20 - B4B		
				Packaging 3 - 21 - B4B		
				Packaging 3 - 22 - B4B		
				Packaging 3 - 23 - B4B	PC CCK168	
				Packaging 3 - 24 - B4B		
				Packaging 3 - 25 - B4B		
				Packaging 3 - 26 - B4B		
				Packaging 3 - 27 - B4B		
				Packaging 3 - 28 - B4B		
				Packaging 3 - 29 - B4B		
				Packaging 3 - 30 - B4B		
				Packaging 3 - 31 - B4B		
				Packaging 3 - 32 - B4B		
				Packaging 3 - 33 - B4B		
				Packaging 3 - 34 - B4B		
				Packaging 3 - 35 - B4B		
				Packaging 3 - 36 - B4B	DAS 21	
200	QC 21 - SA	30 pcs	12/13/19	0.00 0.00	QC 21 - SA - 21	DEC 20 2019
					QC 21 - SA - 70	
					QC 21 - SA - 53	

Part Op 110 - 1-Cut as per Dwg Dwg Rev: A Prog Rev: A 2-Deburr if necessary

Descriptions: 120 - (QC2- Inspect parts off machine FAI/FAIB)

130 - (QC8- inspect parts - second check)

140 - (Outsource process-Anodize per QSI017 4.1.10.1) ISSUE P/O: 45093 HARD ANODIZE, COLOR BLACK AS PER DWG.(SEE NOTE 2)

150 - (Receive & Inspect for Damage & Mat'l Certs)

160 - (QC6- All purchased or subcontracted products)

170 - (Spray Paint / NDT Room) PRIME IAW MIL-P-23377J TYPE1 CLASS N AS PER DWG. (SEE NOTE 2) CARDINAL 4860-50 PRIMER BATCH: _____

180 - (QC14- Inspect Spray Paint)

190 - (Identify as per dwg & Stock Location: _____) ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

200 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.063	2024-T3 .063 Sheet	.5100 sf (.017 ea)	110-Waterjet - Flow - 1	<u>5180490</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Waterjet - Flow - 1	M2024T3S.063	1	166	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Shim	0.200Inches + 0.005 - 0.001	0.205 0.199	0.199	Diameter
2	Shim	0.603Inches ± 0.005	0.608 0.598	0.601	
3	Shim	0.350Inches ± 0.005	0.355 0.345	0.353	
4	Shim	0.700Inches ± 0.005	0.705 0.695	0.702	
5	Shim	2.250Inches ± 0.005	2.255 2.245	2.249	
6	Shim	3.460Inches ± 0.005	3.465 3.455	3.457	
7	Shim	0.063Inches ± 0.005	0.068 0.058	0.065	

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

Job: _____ Part No. _____		DISPOSITION			DEPARTMENT/PROCESS					MRB (QS1042)																													
Date: _____		Sequence #:		QTY Affected:		Disposition					Completed By																												
Description Work Order Deviation											Lead hand / Supervisor																												
											QC / QA Coordinator																												
Root Cause Operator Manufacturing Process Equip/Tooling Handling/Preservation Material Product Improvement Process Improvement Human Factors		FAULT CATEGORY <table border="1"><tr><td>Pressure/Forced</td><td>Contamination</td><td>Power Loss/Surge</td><td>Positioned Wrong</td></tr><tr><td>Bending</td><td>Misaligned/off center</td><td>Folio/Program</td><td>Outside Tolerance</td></tr><tr><td>Crushing</td><td>BOM/Route</td><td>Grain Direction</td><td>Drawing</td></tr><tr><td>Cracks</td><td>Broken/Damage/Defect</td><td>Weld</td><td>Finish</td></tr><tr><td>Crimp/Kink/Ripple/Wave/Twist</td><td>Incomplete/Unclear Instructions</td><td>Wrong Stock Pulled</td><td>Part Lost/Missing</td></tr><tr><td>Marks/Chatter</td><td>Drill Holes</td><td>Out of Sequence</td><td>Misread</td></tr><tr><td>Mislabeled</td><td>Fit/Function</td><td>Off-set/Set-up</td><td></td></tr></table> Other/Details:										Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	Crushing	BOM/Route	Grain Direction	Drawing	Cracks	Broken/Damage/Defect	Weld	Finish	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing	Marks/Chatter	Drill Holes	Out of Sequence	Misread	Mislabeled	Fit/Function	Off-set/Set-up	
Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong																																				
Bending	Misaligned/off center	Folio/Program	Outside Tolerance																																				
Crushing	BOM/Route	Grain Direction	Drawing																																				
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Marks/Chatter	Drill Holes	Out of Sequence	Misread																																				
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **POHB045093**



Supplier: ATG001-VC
A.T.G. Industries Inc
760 INDUSTRIELLE STREET
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045093

PO Date: 11/13/19

Due Date: 11/29/19

Purchase Order

Revision:

Revision Date:

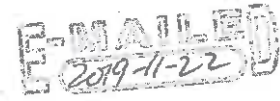
Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pynt Terms: Net 60

Freight Terms:

Special Comments:



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	181338	647.7819	647.7800 Rev A	Cross Bracket Fwd : Various STC's Issue P/O to ATG: HARD ANODIZE COLOR BLACK, AND PRIME AS PER DWG 647.7819	Firmed	-	11/21/19	5 pcs	0 pcs	5 pcs	\$12.27/pcs	\$61.35
Line Item Note ***5 pcs. RUSH***												
	181338-A				Firmed	-	11/29/19	35 pcs	0 pcs	35 pcs	\$12.27/pcs	\$429.45
Sub Total:								40	0	40		\$490.80
2	202746	647.1812	647.1800 Rev NC	Shim : Various STC's (Outsource process- Anodize per QSI017 4.1.10.1) ISSUE P/O: HARD ANODIZE, COLOR BLACK AS PER DWG.(SEE NOTE 2)	Firmed	-	11/21/19	60 pcs	0 pcs	60 pcs	\$7.87/pcs	\$472.20
Line Item Note ***10 pcs. RUSH***												
3	200587	646.3610	646.3600 Rev NC	Filler : Various STC's Issue P/O to ATG : 1- Hard Anodize Black and Prime as per Dwg 646.3600	Firmed	-	11/29/19	20 pcs	0 pcs	20 pcs	\$7.62/pcs	\$152.40



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PURCHASE ORDER **POHB045093**



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	200102	RB6798089-1	6798089 Rev A	Plate Outsource process- Anodize per QSI017 4.1.10.1 -Issue P/O -ANODIZE COLOR RED, PER IAW MIL-A- 8625 TYPE-2 CLASS- 2, Water sealant -Material type; 6061 -Certificate of Conformity is required	Firmed	-	11/29/19	2 pcs	0 pcs	2 pcs	\$41.02/pcs	\$82.04
Grand Total:												\$1,197.44

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/22/19 8:48 AM Dart.Guerin.Kimberley



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Pack List

Number: 919002

Date: 21-Nov-19

Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
60 ea	Part: 647.1812 / Rev: A Shim Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot#: 120908 Expiry Date: 10/20 Job: 26463 Line: 2 PO: POHB045093		
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: NOV 21 2019 Certified Signature: Receiver Signature: Daniel Pouch A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			

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RECEIVED

NOV 22 2019

DART AEROSPACE LTD.

Made in Canada.